

**Work Order ID 64787**

Friday, December 17, 2010 7:54:01 AM

Page 1

Item ID: D2858-2

Accept

Setup Start

Revision ID:

Stop

Item Name: Hinge Bracket

Start Date: 12/16/2010 Start Qty: 24.00

Required Date: 1/19/2011 Req'd Qty: 24.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2858

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

B.A 11/01/06

24

Ø

Jeaspa Bandsaw

Cut blanks 5.850

" Note: 1 Blank Makes 3 Parts

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

B.A 11/01/06

24

Ø

HAAS CNC vertical machine #1

1-Machine per folio FA941

FOLIO REV: C

DWG REV: C

2-Deburr any rough edges

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

B.A 11/01/06

24

Ø

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Friday, December 17, 2010 7:54:01 AM



**Accept**

**Setup Start**

**Stop**



**Start Date:** 12/16/2010      **Start Qty:** 24.00

**Cust Item ID:**

**Required Date:** 1/19/2011      **Req'd Qty:** 24.00



**Customer:**

**Reference:**

Run Start



**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

**Stop**



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.**  
**Stamp**

0.00



SL 11/01/06

QC

## Memo

0.00

## Quality Control

0.00



$\Rightarrow M = 10102$

HandFinish

## Memo

0.00

## Hand Finishing

0.00



M115951

0.00

## Powdercoat

## Memo

## Powder Coating

START TIME:

9:00

□OVEN TEMPERATURE:

☐ FINISH TIME:

920

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

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Item Name: Hinge Bracket

Start Date: 12/16/2010 Start Qty: 24.00

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Required Date: 1/19/2011 Req'd Qty: 24.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

24.00 11/01/13

170

Identify as per dwg &amp; Stock Location: 024

0.00



Packaging

Memo

0.00

Packaging

11/01/14 024

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/14

11.01/14

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Friday, December 17, 2010 7:54:23 AM

Page 1

Work Order ID: 64787

Parent Item: D2858-2

Parent Item Name: Hinge Bracket



Start Date: 12/16/2010

Required Date: 1/19/2011

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP ☐ C ☐ 00.06.22 ☐ Removed P/O for powder coat ☐ EC ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X01.25 0		Purchased	No			110	f	28.2560	0.163	4.117895			



6061-T6 Bar 1.50 x 1.25



Location

Loc Qty

Loc Code

MAT10

28.25595

107461

1.73315

✓ 110936

26.5228

4.1178 <sup>2\*</sup> B.A 11/01/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	64787
<b>Description: Hinge Bracket</b>		<b>Part Number:</b>	D2858-2
<b>Inspection Dwg: D2858 Rev: B</b>		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.171	+0.005/-0.000	Ø0.175	✓		Vern	GA-01
Ø0.400	+0.005/-0.000	Ø0.402	✓		"	"
R0.125	+/-0.010	R0.125	✓		R-6	ref.
0.328	+/-0.010	0.328	✓		Vern	GA-01
0.820	+/-0.005	0.820	✓		"	"
1.476	+/-0.010	1.476	✓		"	"
0.342	+/-0.010	0.342	✓		"	"
0.875	+/-0.010	0.875	✓		"	"
1.56	+/-0.030	1.563	✓		"	"
0.147	+/-0.010	0.148	✓		"	"
0.717	+/-0.010	0.719	✓		"	"
0.697	+/-0.010	0.696	✓		H-6	3100G
0.229	+/-0.010	0.231	✓		Vern	GA-01
R0.125	+/-0.010	R0.125	✓		R-6	ref.
R0.063	+/-0.010	R0.063	✓		"	"
0.063	+/-0.010	0.061	✓		Vern	GA-01
0.126	+/-0.010	0.126	✓		"	"
0.630	+/-0.010	0.629	✓		H-6	3100G
R0.354	+/-0.010	R0.354	✓		R-6	ref.
0.965	+/-0.010	0.963	✓		Vern	GA-01
Ø0.166	+0.005/-0.000	Ø0.168	✓		"	"

<b>Measured by:</b>	B. A	<b>Audited by:</b>	SL	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	11/01/06	<b>Date:</b>	11/01/06	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.11.11	New Issue	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

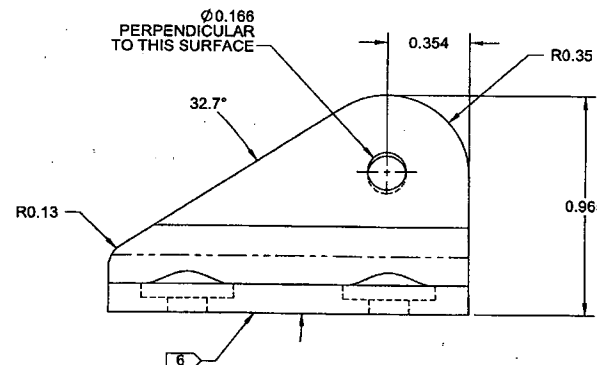
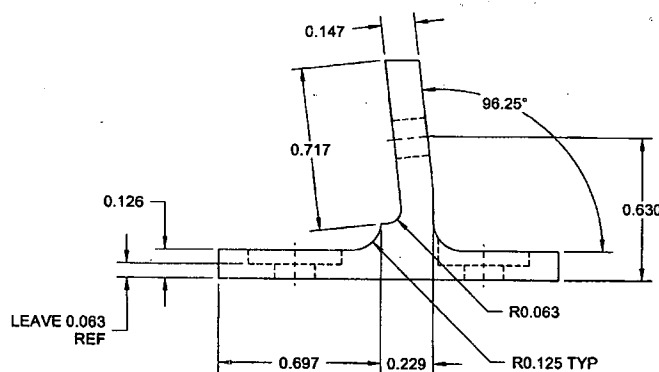
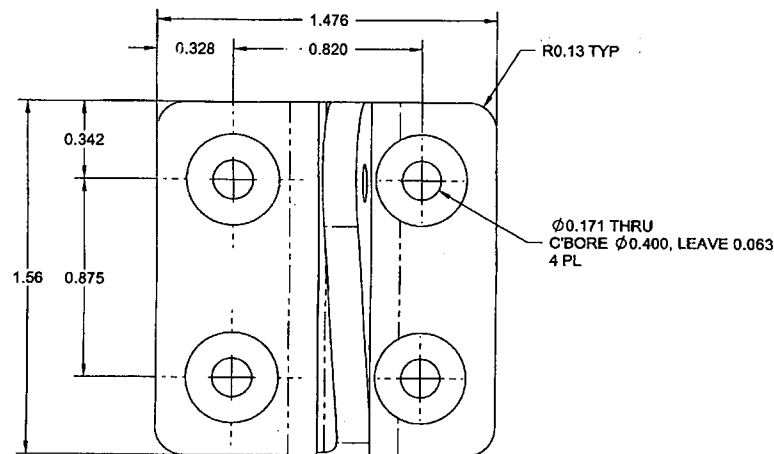
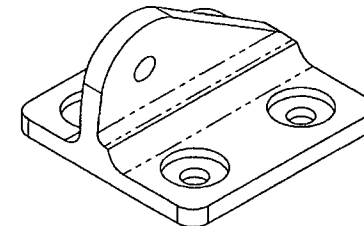
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 49787

*28-0-12-17*



RELEASED  
2010-11-26

# **D2858-1 HINGE BRACKET**

## **NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N "D2858-1" PER DART QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

C	REDRAW TO CURRENT STD. REMOVE ENGRAVED P/N, IDENT. NOW W/ MARKER (A8-1A8-2), REF PAR 10-040	CP	10.10.12
B	0.717 WAS 0.667, 1.56 WAS 1.559	KE	99.02.28
A	NEW ISSUE	KE	98.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP		
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	D2858	SHEET 1 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	HINGE BRACKET	NTS
DATE	10.10.12	<small>COPYRIGHT © 1998 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

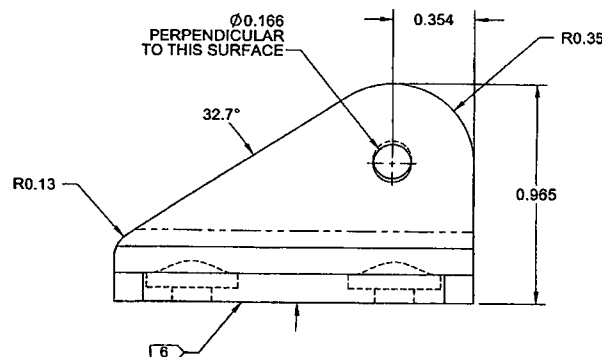
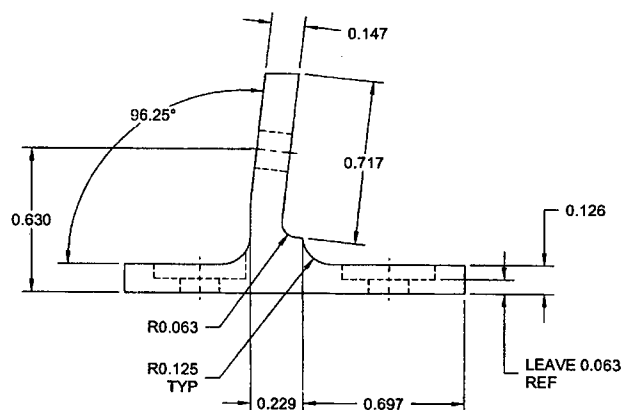
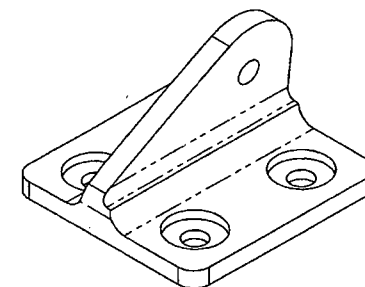
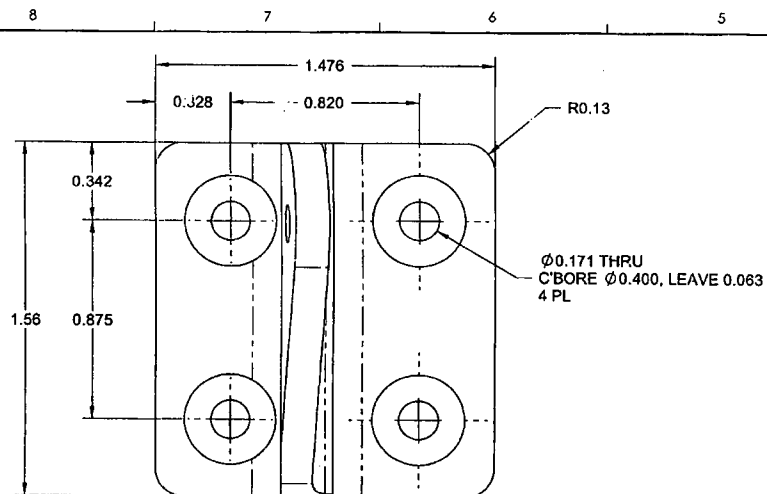
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**D2858-2 HINGE BRACKET**

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N "D2858-2" PER DART QSI 044 6.1
- 7) WEIGHT: 0.04 lbs



DESIGN	KE	<b>DART AEROSPACE LTD</b>	
DRAWN	GP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D2858</b>	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>HINGE BRACKET</b>	NTS
DATE	10.10.12	COPYRIGHT © 1998 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

*w/064787*

**RELEASED**  
2010-11-26

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